

Work Order ID 120054

June-04-14 2:44:01 PM

120054

Page 1

Item ID: D4595-150-13

D4595-150-13

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Sealant Tape (13' Long)

B120054

Stop

NS2

Start Date: 6/04/14

Start Qty: 52.00

52

Cust Item ID:

Required Date: 6/04/14

Req'd Qty: 52.00

52

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 14-06-04

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4595

B

100

0.00

100

Packaging

Purchasing

Memo

0.00

Purchasing

ISSUE P/O:
SUPPLIER: GENERAL SEALANTS
C OF IS REQUIRED

JUN 04/2014

110

0.00

110

Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

DAS
06
9-89

JUN 04/2014

120

0.00

120

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SHP
14/6/4

JUN 04/2014

Work Order ID 120054

120054

Page 2

June-04-14 2:44:01 PM

Item ID: D4595-150-13 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Sealant Tape (13' Long)

Start Date: 6/04/14 Start Qty: 52.00 *52* Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 52.00 *52* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	Identify as per dwg & Stock Location <i>PK14</i>	0.00							
125									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

1197ES

MLJ 1406-18

PH6-18

Picklist Print

June-04-14 2:44:04 PM

Page 1

Work Order ID: 120054

120054

Parent Item: D4595-150-13

D4595-150-13

Parent Item Name: Sealant Tape (13' Long)

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 52.00

Required Qty: 52.00

Comments: IPP REV:I 13.06.26 NEW ISSUE DD VERF:JFS
13.11.14 AS PER DWG REV.B DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4595-150-13P

Purchased

No

Each

0.0000

52

D4595-150-13P

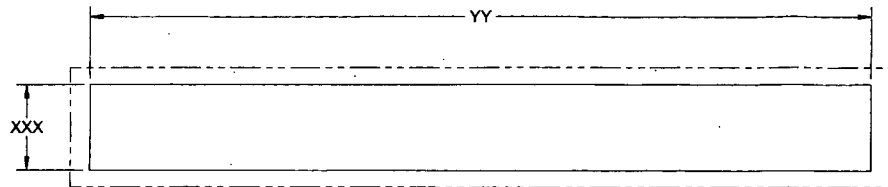
Black Polysulfide Base Sealant 1/16"x1 1/2"x13'

X 56.3333 ' 119 125

**

~~14-6-18~~

SPECIFICATION CONTROL DRAWING



D4595-XXX-YY SEALANT TAPE

RELEASE BACKING, Ref.
DO NOT REMOVE UNTIL APPLICATION

4120054

RELEASED
2013-11-14
MP

NOTES:

1) MATERIAL: SEALANT TAPE, SINGLE-COMPONENT, NON-CURING, POLYSULFIDE BASE
1/16" THICK
PER MIL-S-11030F TYPE III
POSSIBLE SUPPLIER = GENERAL SEALANTS INC. P/N GS#424 (AVIALL)

2) SPECIFICATION: D4595-XXX-YY
WHERE "XXX" = WIDTH IN HUNDREDTHS OF AN INCH
AND "YY" = LENGTH IN FEET
EG. 1 INCH WIDE BY 25 FEET LONG SEALANT TAPE = D4595-100-25.

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4595-XXX-YY", B/N "BXXXXX" PER DART QSI 044 6.1

7) WEIGHT: 0.33 lbs/sq.ft

B	REMOVE NOTE REGARDING TAPE EXPIRATION DATE. REF. PAR13-258.	ML	13.10.03
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	MP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	N/A	D4595	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SEALANT TAPE	NTS
DATE	13.10.03	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
--	--	---	---